



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9713

Job Sheet 210369



Part No: 646.9713

Job Qty: 10 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/8/20

Job Tracking No:

Due Date: 9/1/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.9700 REV.J IPP Rev.A New issue JFS 16/03/08 Verify by: JLM IPP REV:B 2020.05.27 AS PER
DWG REV.J DD VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		8/24/20	0.00	1.71	Bandsaw - 1		ALA 20/07/19
110	HAAS 4 Axis - B4B	10 pcs		8/25/20	0.60	14.71	HAAS - 1 - B4B		ALA 20/07/24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		8/25/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S289943



Part: 646.9713

Job No: 210369

Serial No/Batch: S289943

Revision: Rev.J

Inspector:

Exp Date:

Instructions:

Date: 07/24/20

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86
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20/07/24

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
130	QC 8	10 pcs	8/25/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Outsource - 4 - Anodize	10 pcs	9/1/20		ATG001-VC	5
150	Packaging 2-1 - Receive - B4B	10 pcs	9/1/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 -	

						B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
						Packaging 2 - 37 - B4B	
155 QC 6	10 pcs	9/1/20	0.00	0.00		QC 6 - 9	
						QC 6 - 68	
						QC 6 - 61	
						QC 6 - 40	
						QC 6 - 81	
						QC 6 - 82	
180 Packaging 3-1 - Stock - B4B	10 pcs	9/1/20	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	

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				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	10 pcs	9/1/20	0.00 0.00	QC 21 - SA - 21	DAS 21 AUG 13 2020
				QC 21 - SA - 70	9-09
				QC 21 - SA - 9	
Part Op 100 - (Bandsaw) Cut Blank at 7.425" Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB464 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - Issue P/O to ATG: <u>46802</u> AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW					

MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N
Certification of Conformity is required

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	6 ft (.6 ea)	100-Bandsaw - 1	S288633

Job Allocations

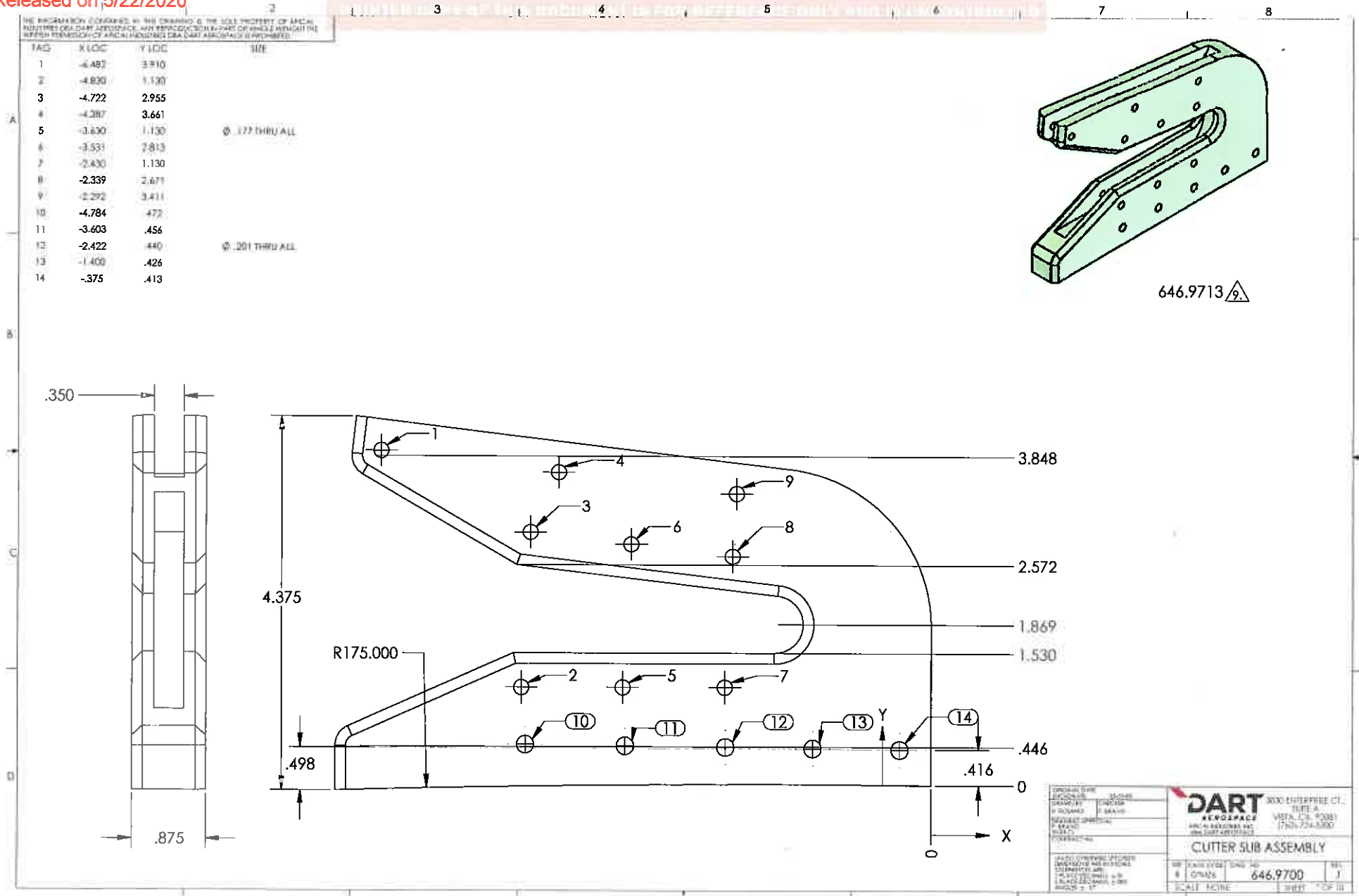
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X5.000	6	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.487Inches ± 0.005	0.492 0.482		
2	Body	4.784Inches ± 0.002	4.786 4.782		
3	Body	3.603Inches ± 0.002	3.605 3.601		
4	Body	2.422Inches ± 0.002	2.424 2.420		
5	Body	1.400Inches ± 0.002	1.402 1.398		
6	Body	0.375Inches ± 0.002	0.377 0.373		
7	Body	0.409Inches ± 0.002	0.411 0.407		
8	Body	0.350Inches + 0.005 - 0.000	0.355 0.350		
9	Body	0.875Inches ± 0.005	0.880 0.870		
10	Body	1.067Inches ± 0.002	1.069 1.065		
11	Body	2.608Inches ± 0.002	2.610 2.606		
12	Body	2.750Inches ± 0.002	2.752 2.748		
13	Body	2.892Inches ± 0.002	2.894 2.890		
14	Body	3.348Inches ± 0.002	3.350 3.346		
15	Body	3.597Inches ± 0.002	3.599 3.595		
16	Body	3.847Inches ± 0.002	3.849 3.845		
17	Body	0.544Inches ± 0.002	0.546 0.542		
18	Body	2.195Inches ± 0.002	2.197 2.193		
19	Body	3.395Inches ± 0.002	3.397 3.393		
20	Body	3.495Inches ± 0.002	3.497 3.493		
21	Body	4.595Inches ± 0.002	4.597 4.593		
22	Body	4.687Inches ± 0.002	4.689 4.685		
23	Body	4.734Inches ± 0.002	4.736		

				4.732
24	Body	0.177Inches	+ 0.005 - 0.001	0.182 0.176
25	Body	0.201Inches	+ 0.005 - 0.001	0.206 0.200
26	Body	0.130Inches	± 0.010	0.140 0.120
27	Body	45.0Angle	± 0.5	45.5 44.5
28	Body	1.5Angle	± 0.0	1.5 1.5
29	Body	0.660Inches	± 0.005	0.665 0.655
30	Body	0.660Inches	± 0.005	0.665 0.655
31	Body	0.700Inches	± 0.005	0.705 0.695
32	Body	5.500Inches	± 0.005	5.505 5.495
33	Body	6.8Angle	± 0.5	7.3 6.3

Plex 6/8/20 7:03 AM Dart.lajeunesse.marie



DART AEROSPACE LTD		Work Order: 210369
Description: Body		Part Number: 646.9713
Inspection Dwg: 646.9700 Rev: J		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.482	$\pm .002$	6.483			HG	3/006
4.830	$\pm .002$	4.834			"	"
4.722	$\pm .002$	4.723			"	"
4.387	$\pm .002$	4.388			"	"
3.630	$\pm .002$	3.631			"	"
3.531	$\pm .002$	3.531			"	"
2.430	$\pm .002$	2.431			"	"
2.339	$\pm .002$	2.340			"	"
2.292	$\pm .002$	2.293			"	"
4.784	$\pm .002$	4.785			"	"
3.603	$\pm .002$	3.604			"	"
2.422	$\pm .002$	2.423			"	"
1.400	$\pm .002$	1.401			"	"
.375	$\pm .002$	.376			"	"
3.910	$\pm .002$	3.910			"	"
1.130	$\pm .002$	1.1305			"	"
2.955	$\pm .002$	2.9445			"	"
3.661	$\pm .002$	3.661			"	"
1.130	$\pm .002$	1.1305			"	"
2.813	$\pm .002$	2.813			"	"
1.130	$\pm .002$	1.130			"	"
2.671	$\pm .002$	2.6715			"	"
3.411	$\pm .002$	3.412			"	"
.472	$\pm .002$	.4725			"	"
.456	$\pm .002$	.4565			"	"
.440	$\pm .002$	.441			"	"
.426	$\pm .002$	.4265			"	"
.413	$\pm .002$	.414			"	"
Ø.177	$\pm .005 / -.001$	.177			GP	Ref.
Ø.201	$\pm .005 / -.001$	.201			GP	Ref.
.350	$\pm .005 / -.000$	.352				
.875	$\pm .005$	.874			MAN	B190017734

Measured by: ALA	Checked by: DTD	QC Inspector:
Date: 20/07/23	Date: 2007-25	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046802



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046802

PO Date: 7/28/20

Due Date: 8/7/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211044	646.2910	646.2900 Rev N/C	Deflector Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	8/7/20	12 pcs	0 pcs	12 pcs	\$49.73/pcs	\$596.76



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

POHB046802



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	210880	646.9715	646.9700 Rev.J	Body : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	8/7/20	10 pcs	0 pcs	10 pcs	\$16.23/pcs	\$162.30
3	210465	D4824-1	D4824 Rev A	Upper Cutter Mount : Certificate of Conformity only Issue P/O: Black Anodize as per Dwg D4824 PRIME AS PER DWG, SEE NOTE #2	Firmed	-	8/7/20	7 pcs	0 pcs	7 pcs	\$15.13/pcs	\$105.91



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB046802



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	210369	646.9713	646.9700 Rev.J	Body Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X10	-	8/7/20	10 pcs	0 pcs	10 pcs	\$16.23/pcs	\$162.30
									AUG 11 2020			
5	209021	646.9910	646.9900 Rev nc1	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed X15	-	8/7/20	15 pcs	0 pcs	15 pcs	\$15.13/pcs	\$226.95
									AUG 11 2020			
6	210883-A	647.1515	647.1500 Rev E	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X2	-	8/7/20	2 pcs	0 pcs	2 pcs	\$13.78/pcs	\$27.56
									AUG 11 2020			

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046802



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	211201	D5771-15	D5771 REV.A	Curved Washer -Issue P/O; ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed X8	-	8/7/20	8 pcs AUG 11 2020	0 pcs	8 pcs	\$6.41/pcs	\$51.28
8	211206	D5771-13	D5771 REV.A	Crescent Bushing -Issue P/O; ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed X8	-	8/7/20	8 pcs AUG 11 2020	0 pcs	8 pcs	\$6.41/pcs	\$51.28

Grand Total: \$1,384.34

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920618

Date: 10-Aug-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.9715 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Job: 27849 PO: POHB046802		Rev: J Expiry Date: Line: 2
10 ea	Part: 646.9713 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Job: 27862 PO: POHB046802		Rev: J Expiry Date: Line: 4
15 ea	Part: 646.9910 Struts Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Job: 27899 PO: POHB046802		Rev: NC Expiry Date: Line: 5
Made in Canada.			

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RECEIVED
AUG 11 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920618

Date: 10-Aug-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>AUG 10 2020</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			

Entered: 12 Date: Aug 13/2020



NCR No. 20-8277

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>210 364</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>646.9713</u>		Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
		Scrap ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Water Jet ☐	
		Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐	
Date: <u>20-07-22</u>		Sequence #: <u>110</u>		QTY Affected: <u>2</u>		DAS MRB (QSI042) 9 9-89	
Description Work Order Deviation				Disposition		<u>20-07-24</u>	
Program didn't match the drawing rev. Some cutes as changed Old Rev was Rev G, now is Rev J <u>Programs have been updated to Rev. J</u>				Update program SCRAP and destroy → Program were updated <u>20/07/23</u>		Completed By <u>ALA 20/07/23</u>	
						Lead hand / Supervisor <u>20/07/23</u>	
						QC / QA Coordinator DAS 9 9-89 <u>20-07-24</u>	
Root Cause		FAULT CATEGORY					
Operator ☐		☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong		
Manufacturing Process ☒		☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance		
Equip/Tooling ☐		☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing		
Handling/Preservation ☐		☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish		
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Product Improvement ☐		☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread		
Process Improvement ☐		☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up			
Human Factors ☐		Other/Details:					